

Work Order ID 162906

Friday, June 16, 2017 8:15:48 AM

162906

Page 1

Item ID: D4148-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Crosstube Lug Assembly
 Start Date: 7/5/2017 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 7/7/2017 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: ^{DAS}21 Date: JUN 16 2017 Tooling: Date: Run Start *NR1*
 QC: ⁹⁻⁸⁹ Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	E	Pick kit				DAS 6 9-89	(6)	JUN 20 2017	
100		0.00							
100									
Small Fab	Memo	1.56							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.12							
Quality Control									
120	Identify as per dwg & Stock Location: ⁷⁻⁵⁹	0.00							
120									
Packaging	Memo	0.06							
Packaging									

DAS
36
9-89

17/06/21

DAS
38
9-89

JUN 22 2017

DAS
6
9-89

JUN 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

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162906

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Required Date: 7/7/2017 Req'd Qty: 6.00 ***6*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.60							
Quality Control									

DAS
21
9-89

JUN 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Friday, June 16, 2017 8:15:46 AM

Page 1

Work Order ID: 162906

162906

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

IPP Rev:C

10.10.29 as per revC DD verf:EC

IPP REV:D 11.03.02

AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	685.0000	4	12			

MS21043-3

Nut

**

DAS

6

89

JUN 20 2017

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	119	
m136182	119	
GA	88	
m136182	88	
OVER007	300	
m137587	300	
ST302	98	
m137459	98	

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
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Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
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Picklist Print

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Page 2

Work Order ID: 162906

162906

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 6.00

Required Qty: 6.00

MS21043-4

Purchased

No

100

Each

857.0000

1

18

MS21043-4

Nut

**

DAS

6

9-89

JUN 20 2017

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

99

m132803

5

m137371

94

OVER007

300

m137886

300

ST302

418

m137361

218

m137371

200

18

D2690-6

Manufactured

No

100

Each

30.0000

1

6

D2690-6

Lanyard

**

DAS

6

9-89

JUN 20 2017

Location

Loc Qty

Loc Code

ST009

30

159568

30

D3910-1

Manufactured

No

100

Each

20.0000

1

6

D3910-1

Crosstube Lug

**

DAS

6

9-89

JUN 20 2017

Location

Loc Qty

Loc Code

ST525

20

159145

20

Friday, June 16, 2017 8:15:46 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Friday, June 16, 2017 8:15:46 AM

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Work Order ID: 162906

162906

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 6.00

Required Qty: 6.00

D4091-1
D4091-1
Mounting Lug

Manufactured No 100 Each 36.0000 1 6
**

JUN 20 2017 6:00
DAS 9-89

Location Loc Qty Loc Code

ST525 36
161296 36

D4148-1
D4148-1
Crosstube Lug Plate, Fwd

Manufactured No 100 Each 23.0000 2 12
**

JUN 20 2017 6:00
DAS 9-89

Location Loc Qty Loc Code

ST085 23
161842 23

D4148-3
D4148-3
Stud Receiver, Lower

Manufactured No 100 Each 13.0000 1 6
**

JUN 20 2017 6:00
DAS 9-89

Location Loc Qty Loc Code

ST086 13
157016 10
159557 3

D4148-5
D4148-5
Eyebolt Stud

Manufactured No 100 Each 21.0000 1 6
**

JUN 20 2017

Location Loc Qty Loc Code

ST086 21
158933 21

6

DAS 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 162906

162906

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 6.00

Required Qty: 6.00

AN3C12A Purchased No

100 Each 103.0000 2 12

AN3C12A

Bolt

**

DAS 6 JUN 28 2017
9-89

Location	Loc Qty	Loc Code
GA	28	
M128727	7	
M133990	21	
ST349	75	
M137507	75	

AN4C13A Purchased No

100 Each 78.0000 3 18

AN4C13A

BOLT

**

DAS 6 JUN 28 2017
9-89

Location	Loc Qty	Loc Code
GA	26	
m137699	26	
ST344	52	
m137321	2	
m137495	50	

MS17984-C413 Purchased No

100 Each 35.0000 1 6

MS17984-C413

Quick Release Pin

**

DAS 6 JUN 28 2017
9-89

Location	Loc Qty	Loc Code
ST315	35	
m137478	26	
m137587	9	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																										
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																										
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																										
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																										
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																																																																													
Misidentified ☐	Past Due ☐																																																																														

Picklist Print

Friday, June 16, 2017 8:15:46 AM

Page 5

Work Order ID: 162906

162906

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 7/5/2017

Required Date: 7/7/2017

Start Qty: 6.00

Required Qty: 6.00

MS20615-4M18

Purchased

No

100

Each

145.0000

8

48

MS20615-4M18

**

Rivet

Location

Loc Qty

Loc Code

GA

40

m134762

40

ST306

105

m137361

100

m137459

5

NAS1149C0332R

Purchased

No

100

Each

3,160.000

4

24

NAS1149C0332R

**

WASHER

Location

Loc Qty

Loc Code

FP001

1590

m137597

1590

GA

514

m133284

22

m136444

492

ST266

1056

m137381

1056

NAS1149C0432R

Purchased

No

100

Each

1,324.000

6

36

NAS1149C0432R

**

WASHER

Location

Loc Qty

Loc Code

GA

341

m134676

341

ST266

19

m136986

19

Sy266

964

m137459

964

JUN 20 2017

DAS

6

9-89

JUN 20 2017

DAS

6

9-89

JUN 20 2017

DAS

6

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	